

# Work Order ID 110117

December-17-13 9:15:29 AM

**\*110117\***

Page 1

Item ID: D3914-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Long Basket Lid Assembly (350)  
Start Date: 12/17/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 12/17/13 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: MLS Date: 12-12-19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3914    | C            |
| D4020    | A            |

100 Weld per dwg A/R S.S. rod Batch: B123823 0.00  
Large Fab  
**\*100\***  
Large Fab  
Large Fab  
Memo 0.00  
1- assemble ribs, weld as per dwg D3914 using DT9607A  
2- weld hinge (3) and Mounting brackets as per dwg D3914  
\*\*\*Visual inspect before welding mesh\*\*\*  
3- tack weld mesh on basket as per dwg D3914  
\*\*\*Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

1x CC 14-2-6

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00  
**\*110\***  
QC Memo 0.00  
Quality Control

① 1402-07

DAS  
9  
9-89

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Stop \*NR2\*

\*\*\*Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label \*\*\*

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Item ID: D3914-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Long Basket Lid Assembly (350)

Start Date: 12/17/13 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00

DAS

27

9-89

**\*150\***

QC

Memo

0.00

Quality Control

14-2-12

160

Identify as per dwg & Stock Location: w/o

0.00

D-4030-041/13110165

**\*160\***

Packaging

Memo

0.00

Packaging

1x 6 22 14/02/11

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

14-02-12  
14-02-12

# Picklist Print

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Work Order ID: 110117

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD  
10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD VERF:JLM  
IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

| Component Item ID/<br>Item Name                 | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3914-1<br>Rib                                  |                        | Manufactured  | No          |                     |                  | 100             | Each               | 8.0000         | 2           | 2            |               | CC 14-2-6      |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                |        |
|   |                        |               |             | WA004               |                  | 8               | B105978            |                |             | (2x)         |               |                |        |
|   |                        |               |             | 105977              |                  | 8               |                    |                |             |              |               |                |        |
| D3914-7<br>Rib                                  |                        | Manufactured  | No          |                     |                  | 100             | Each               | 6.0000         | 2           | 2            |               | CC 14-2-6      |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                |        |
|   |                        |               |             | WA004               |                  | 6               | B110182            |                |             | (2x)         |               |                |        |
|   |                        |               |             | 107271              |                  | 6               |                    |                |             |              |               |                |        |
| D4018-5<br>Rib                                  |                        | Manufactured  | No          |                     |                  | 100             | Each               | 24.0000        | 9           | 9            |               | CC 14-2-6      |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                |        |
|   |                        |               |             | WA004               |                  | 24              | B107981            |                |             |              |               |                |        |
|   |                        |               |             | 100347              |                  | 3               | B107231            |                |             | (9x)         |               |                |        |
|   |                        |               |             | 104988              |                  | 18              |                    |                |             |              |               |                |        |
|   |                        |               |             | 106726              |                  | 3               |                    |                |             |              |               |                |        |
| D4035-043<br>Lid Rib Assembly, Aft (350 Basket) |                        | Manufactured  | No          |                     |                  | 100             | Each               | 2.0000         | 2           | 2            |               | CC 14-2-6      |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                |        |
|   |                        |               |             | WA004               |                  | 2               | B107981            |                |             | (2x)         |               |                |        |
|   |                        |               |             | 107509              |                  | 1               |                    |                |             |              |               |                |        |
|   |                        |               |             | 108589              |                  | 1               |                    |                |             |              |               |                |        |

# Picklist Print

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Work Order ID: 110117

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 264.0000 2 2 CC 14-2-6  
Mounting Bracket

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA004    | 264     |          |
| 102265   | 94      |          |
| 103683   | 98      |          |
| 105886   | 48      |          |
| 107768   | 24      |          |

D4016-3 Manufactured No 100 Each 43.0000 3 3 CC 14-2-6  
Hinge Half, Lid

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA004    | 43      | B111054  |
| 103029   | 23      | B111573  |
| 106882   | 20      |          |

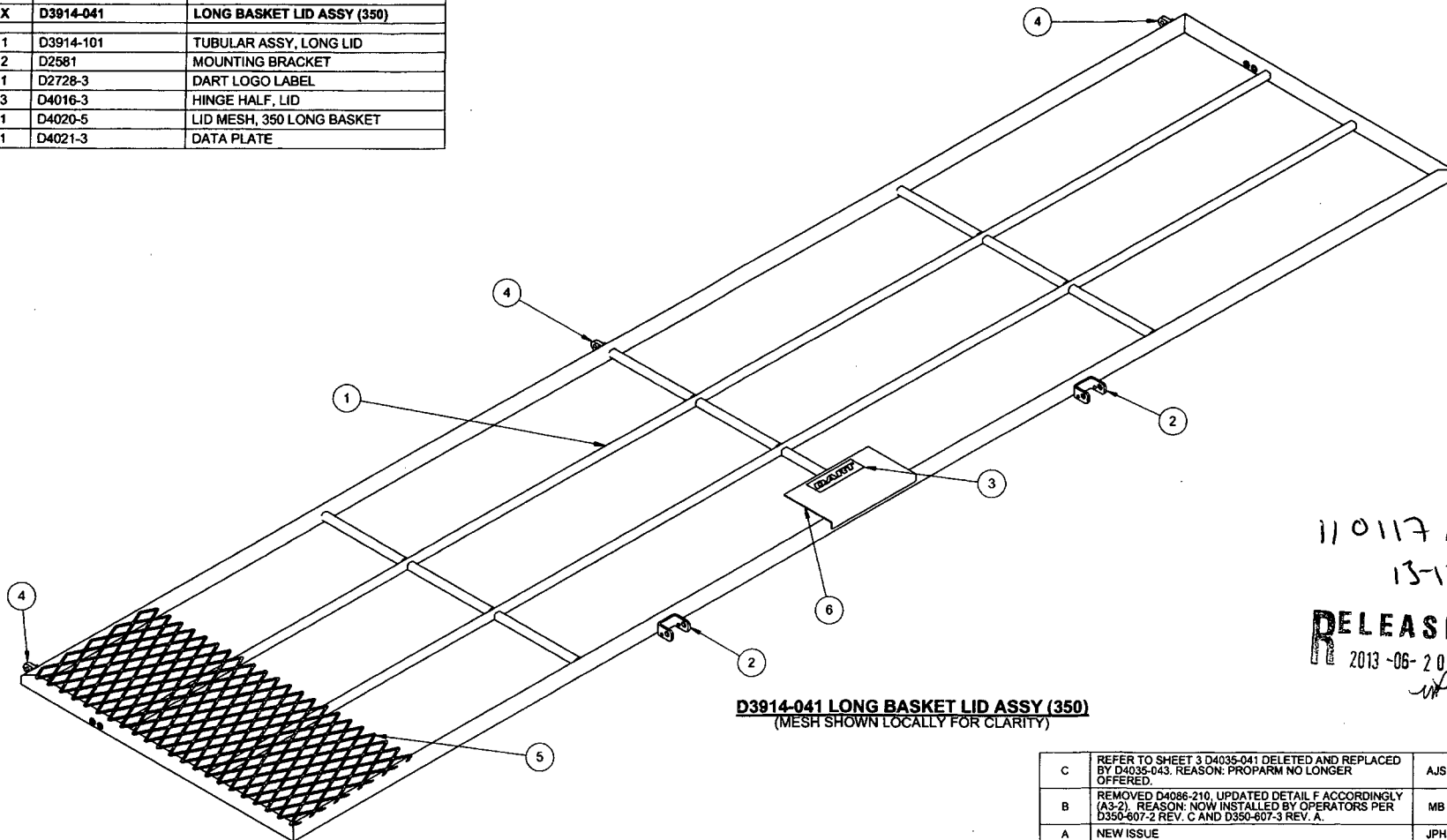
D4020-5 Manufactured No 100 Each 1.0000 1 1 CC 14-2-6  
Mesh (350 Basket Long, Lid)

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA004    | 1       | B110222  |
| 107300   | 1       |          |

D4021-3 Manufactured No 100 Each 27.0000 1 1 CC 14-2-6  
Data Plate

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA004    | 27      |          |
| 101346   | 27      |          |

| ITEM | QTY<br>-041 | P/N       | DESCRIPTION                |
|------|-------------|-----------|----------------------------|
|      | X           | D3914-041 | LONG BASKET LID ASSY (350) |
| 1    | 1           | D3914-101 | TUBULAR ASSY, LONG LID     |
| 2    | 2           | D2581     | MOUNTING BRACKET           |
| 3    | 1           | D2728-3   | DART LOGO LABEL            |
| 4    | 3           | D4016-3   | HINGE HALF, LID            |
| 5    | 1           | D4020-5   | LID MESH, 350 LONG BASKET  |
| 6    | 1           | D4021-3   | DATA PLATE                 |

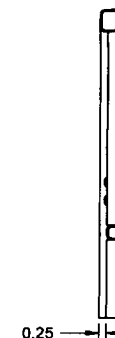


**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

110117 MCT  
13-12-19  
**RELEASED**  
2013-06-20

| C          | REFER TO SHEET 3 D4035-041 DELETED AND REPLACED BY D4035-043. REASON: PROFORM NO LONGER OFFERED.  | AJS   | 13.03.13 |
|------------|---|---|----------|
| B          | REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A. | MB  | 10.08.05 |
| A          | NEW ISSUE   | JPH   | 10.03.16 |
| REV.       | DESCRIPTION   | BY  | DATE     |
| DESIGN     | AJS   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br>DRAWING NO. <b>D3914</b><br>TITLE <b>LONG BASKET LID ASSY (350)</b><br><small>COPYRIGHT © 2010 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |          |
| DRAWN      | AJS   |   |          |
| CHECKED    | A.P.  |   |          |
| MFG. APPR. | NS  |   |          |
| APPROVED   | NS  |   |          |
| DE APPR.   | NS  | REV. C<br>SHEET 1 OF 4<br>SCALE<br>NTS  |          |
| DATE       | 13.03.13  |   |          |

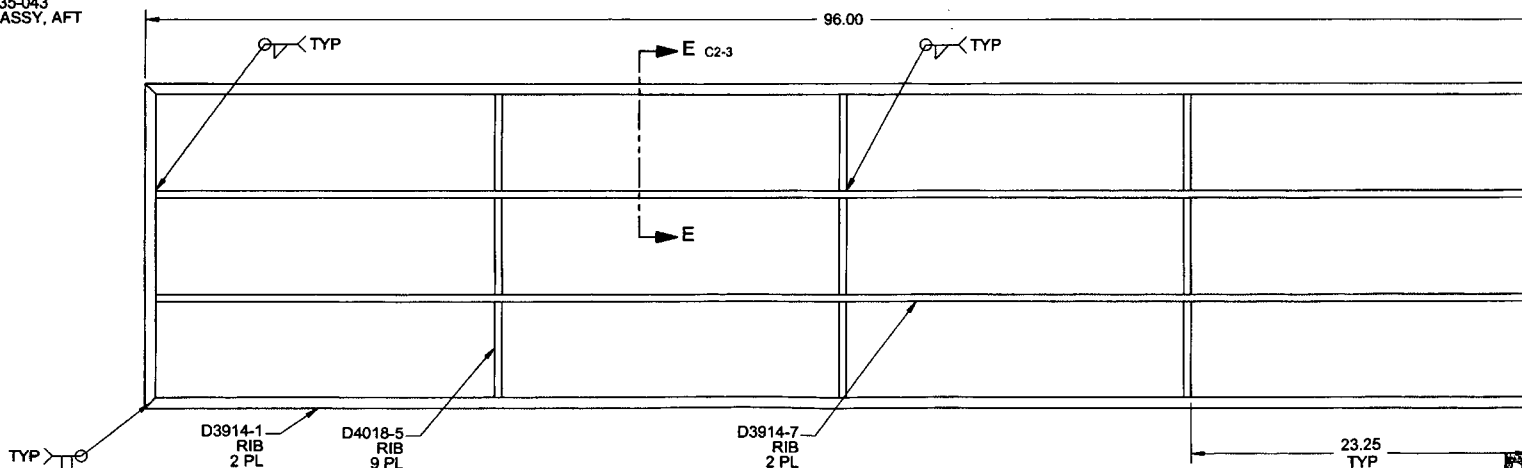
| ITEM | QTY<br>-101 | P/N       | DESCRIPTION                  |
|------|-------------|-----------|------------------------------|
|      | X           | D3914-101 | TUBULAR ASSY, LONG LID (350) |
| 1    | 2           | D3914-1   | RIB                          |
| 2    | 2           | D3914-7   | RIB                          |
| 3    | 9           | D4018-5   | RIB                          |
| 4    | 2           | D4035-043 | BASKET LID RIB ASSY, AFT     |



SECTION E-E C5-3

D4035-043  
RIB ASSY, AFT

D4035-043  
RIB ASSY, AFT



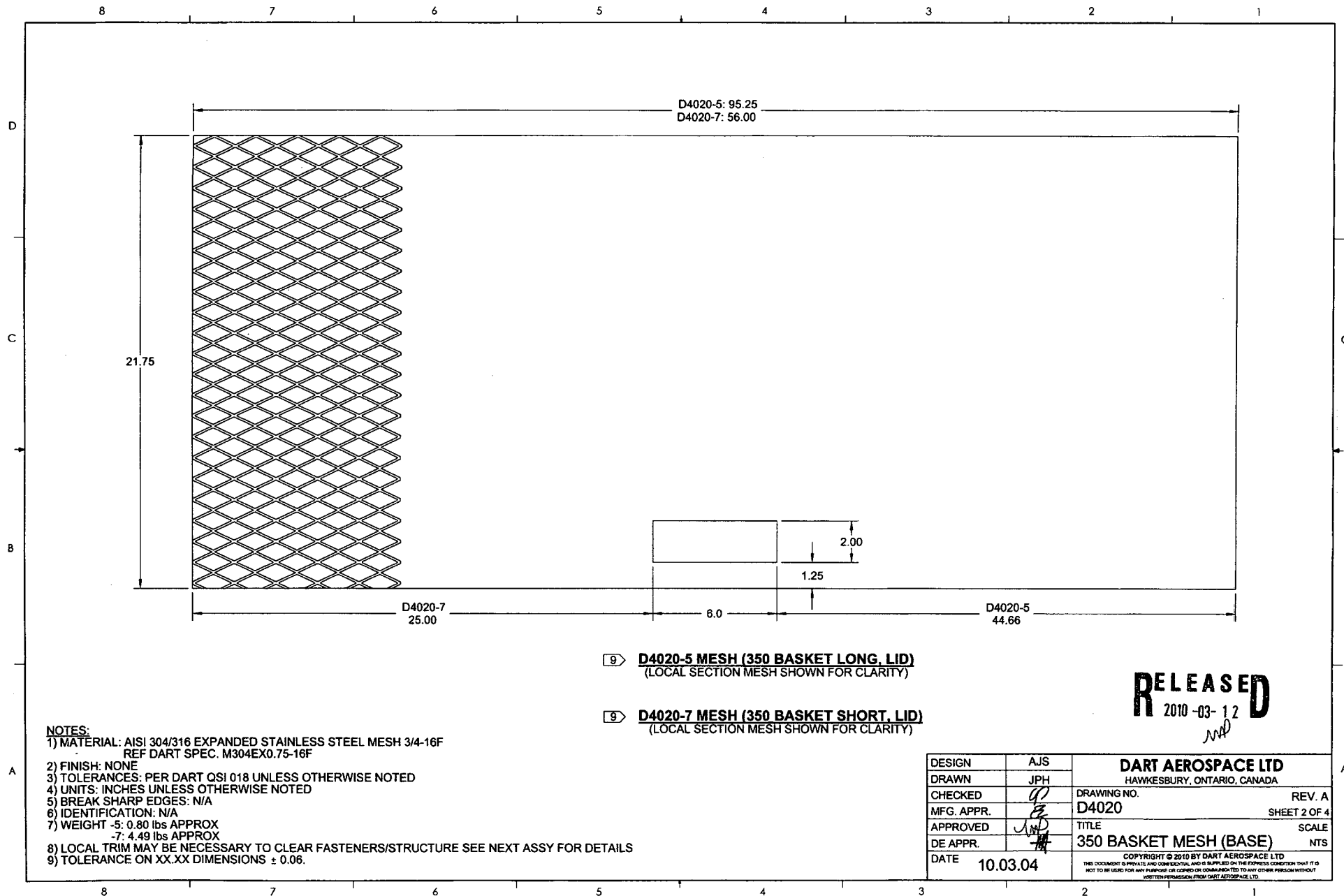
8 D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3914-101
- 9) WELD PER DART QSI 004

|  |          |  |              |
|--|----------|--|--------------|
| DESIGN   | AJS      | DART AEROSPACE LTD                     |              |
| DRAWN  | AJS      | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED  | A.P.     | DRAWING NO.                            | REV. C       |
| MFG. APPR.   | IS       | D3914                                  | SHEET 3 OF 4 |
| APPROVED   | AP       | TITLE                                  | SCALE        |
| DE APPR.   | AP       | LONG BASKET LID ASSY (350)             | NTS          |
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RELEASED  
2013-06-20



- 9 D4020-5 MESH (350 BASKET LONG, LID)  
(LOCAL SECTION MESH SHOWN FOR CLARITY)
- 9 D4020-7 MESH (350 BASKET SHORT, LID)  
(LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:  
 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F  
 REF DART SPEC. M304EX0.75-16F  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: N/A  
 7) WEIGHT -5: 0.80 lbs APPROX  
 -7: 4.49 lbs APPROX  
 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS  
 9) TOLERANCE ON XX.XX DIMENSIONS  $\pm 0.06$ .

**RELEASED**  
 2010-03-12  
*MD*

|            |                    |  |              |
|------------|--------------------|--|--------------|
| DESIGN     | AJS                | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | JPH                |  |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.  | REV. A       |
| MFG. APPR. | <i>[Signature]</i> | <b>D4020</b>   | SHEET 2 OF 4 |
| APPROVED   | <i>[Signature]</i> | TITLE  | SCALE        |
| DE APPR.   | <i>[Signature]</i> | <b>350 BASKET MESH (BASE)</b>  | NTS          |
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